

# Work Order ID 74493

Monday, October 03, 2011 10:43:57 AM



Page 1

Item ID:	D3394-043	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Lug Assembly					
Start Date:	9/30/2011	Start Qty:	50.00			
Required Date:	10/11/2011	Req'd Qty:	50.00			
Reference:						

Approvals:	Process Plan: <u>M.L.J</u>	Date: <u>11/10/03</u>	Tooling:		Date:	
	QC:	Date:	SPC (Y/N):		Date:	

Run	Start	
	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3394 DEO	Rev B								

100		0.00	
	BAND SAW		
Bandsaw	Memo	0.00	
Jeaspa Bandsaw	Cut Blank to .850"		

*cut at Metee*

120		0.00	
	HAAS 1		
HAAS CNC vertical machine #1	Memo	0.00	
	MILL AS PER DWG AND FOLIO FA808		
	FOLIO REV: _____		
	DWG REV: _____		

*Purchasing*

DEBURR

*Issue PO 15029  
machine per dwg D3394-Rev.B*

*11-10-3*

*18.95*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 74493

Monday, October 03, 2011 10:43:57 AM



Page 2

Item ID: D3394-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug Assembly

Start Date: 9/30/2011 Start Qty: 50.00



Cust Item ID:

Required Date: 10/11/2011 Req'd Qty: 50.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

*Paduzejing*

*Review + Inspect for front damage  
ensure CS C attached*

*Run 10/11/17 (50)*

135

QC3 Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

*Sulcolor*

*count  
(x50)*

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

*50X0 m-11/10/17*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**Work Order ID 74493**

Monday, October 03, 2011 10:43:57 AM



Page 3

Item ID: D3394-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug Assembly

Start Date: 9/30/2011 Start Qty: 50.00



Cust Item ID:

Required Date: 10/11/2011 Req'd Qty: 50.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Powdercoat

0.00

Powder Coating

Memo

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

160

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

170

Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg D3394

50XØM-11/10/20

50 BR 11-10-20

GB 11/10/24 (50)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**Work Order ID 74493**

Monday, October 03, 2011 10:43:57 AM



Page 4

Item ID: D3394-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug Assembly

Start Date: 9/30/2011 Start Qty: 50.00



Cust Item ID:

Required Date: 10/11/2011 Req'd Qty: 50.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00		8 uuo6r		(50)			
190  Packaging Packaging	Identify as per dwg & Stock Location: 479  Memo	0.00 0.00				11/11/11	(50)		
200  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00 0.00							11/11/01 MF 11-11-01

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

**Part No:** \_\_\_\_\_ **PAR #:** \_\_\_\_\_ **Fault Category:** \_\_\_\_\_ **NCR:** Yes No **DQA:** \_\_\_\_\_ **Date:** \_\_\_\_\_  
**Resolution:** \_\_\_\_\_ **Disposition:** \_\_\_\_\_ **QA: N/C Closed:** \_\_\_\_\_ **Date:** \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Page 1

Monday, October 03, 2011 10:44:01 AM

Work Order ID: 74493

Parent Item: D3394-043

Parent Item Name: Lug Assembly




Start Date: 9/30/2011

Required Date: 10/11/2011

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP Rev: A New Issue 06-01-06 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS35489-93  GROMMET		Purchased	No			100	Each	155.0000	2	100			
<div> <div>Location</div> <div>ST296</div> <div>116235</div> </div> <div> <div>Loc Qty</div> <div>155</div> <div>155</div> </div> <div> <div>Loc Code</div> </div>													
D2423  Lug Extrusion		Manufactured	No			110	f	505.7300	0.07	3.684211			
<div> <div>Location</div> <div>MAT006</div> <div>43722</div> <div>45800</div> <div>68331</div> </div> <div> <div>Loc Qty</div> <div>505.73</div> <div>161.5</div> <div>1</div> <div>343.23</div> </div> <div> <div>Loc Code</div> </div>													
D3394-3P  Lug		Purchased	No			170	Each	0.0000	1	50			

*Handwritten:* 5/11/10/14  
M119309 100x

*Handwritten:* 3.684211  
5/11/14 (50)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

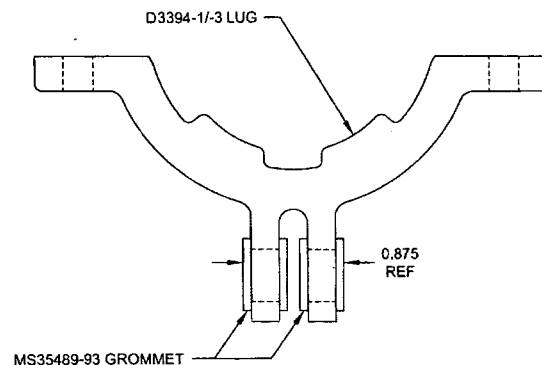
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

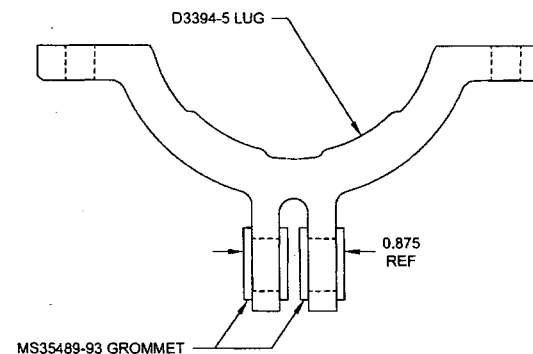
**NOTE:** Date & initial all entries

QTY. -041	QTY. -043	QTY. -045	PART NUMBER	DESCRIPTION
X			D3394-041	LUG ASSEMBLY
	X		D3394-043	LUG ASSEMBLY
		X	D3394-045	LUG ASSEMBLY
1			D3394-1	LUG
	1		D3394-3	LUG
		1	D3394-5	LUG
2	2	2	MS35489-93	GROMMET

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 74493 M.L.J  
11/10/03



D3394-041/-043 LUG ASSEMBLY



D3394-045 LUG ASSEMBLY

DEO ATTACHED

RELEASED  
09/04/02

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.20 lbs APPROX

B	ADDED -045, SHT 4 ADDED FILLETS IN SECTION A-A. SEE PAR 152	AJS	09.04.02
A	NEW ISSUE	PH	05.02.14
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3394	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LUG	NTS
DATE	09.04.02	<small>COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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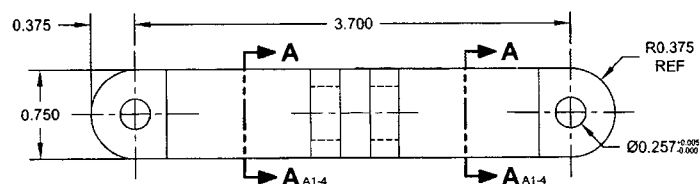
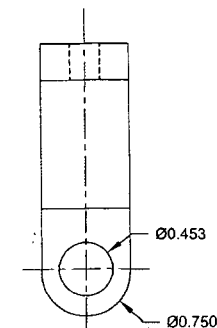
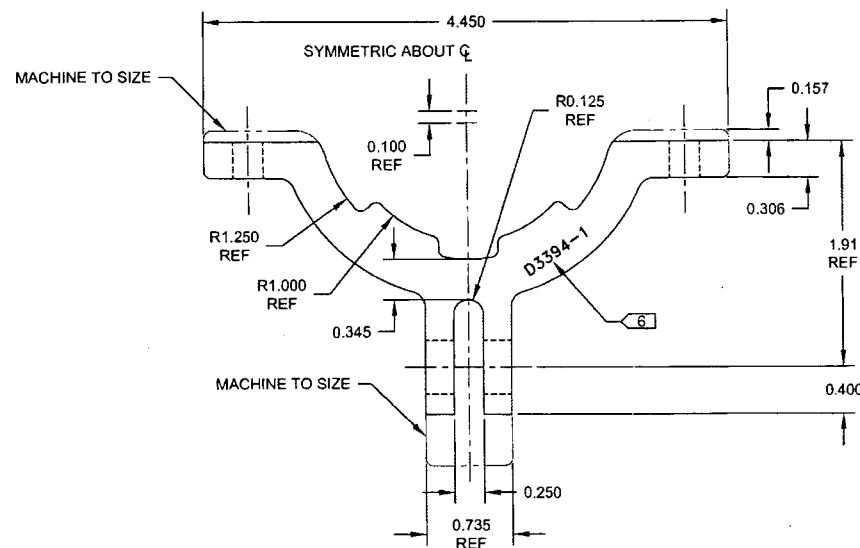
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

74493



D3394-1 LUG

DEO ATTACHED

RELEASED  
09/26/25-11

## NOTES:

- 1) MATERIAL: MAKE FROM D2423
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO DEPTH OF 0.010±0.005 IN THIS LOCATION.  
WITH TOOL A TIP RADIUS OF 0.015±0.005
- 7) WEIGHT: 0.18 lbs

DESIGN	PH	<b>DART AEROSPACE LTD</b>	
DRAWN	ALS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3394	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LUG	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

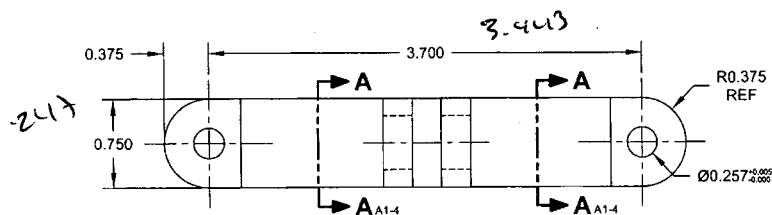
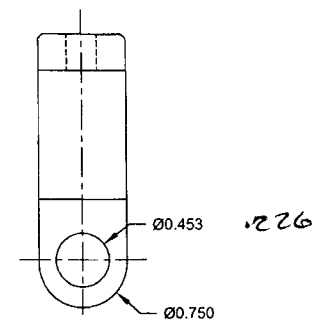
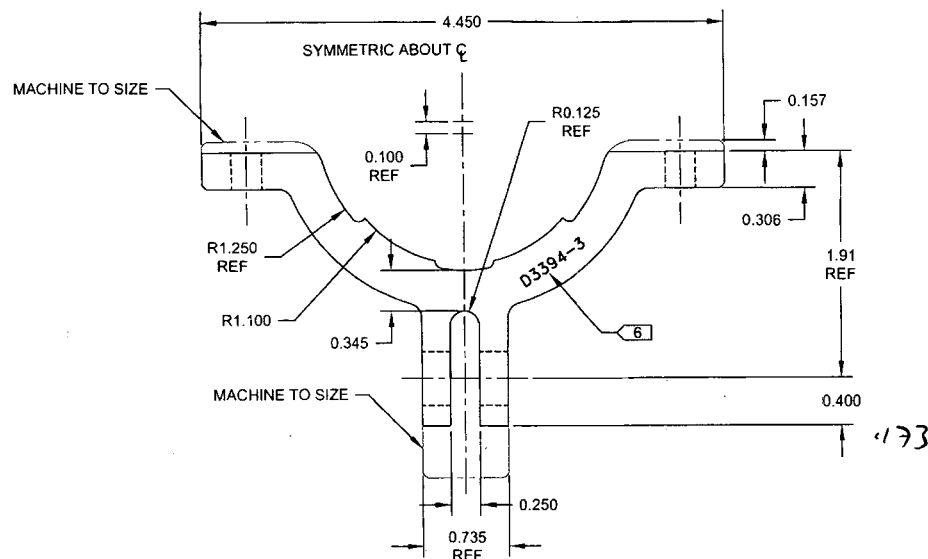
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

74493





D3394-3 LUG

DEO ATTACHED

RELEASED  
09/04/25

## NOTES:

- 1) MATERIAL: MAKE FROM D2423
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO DEPTH OF 0.010±0.005 IN THIS LOCATION,  
WITH TOOL A TIP RADIUS OF 0.015±0.005
- 7) WEIGHT: 0.18 lbs

DESIGN	PH	<b>DART AEROSPACE LTD</b>	
DRAWN	A.S.	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3394	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LUG	NTS
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**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

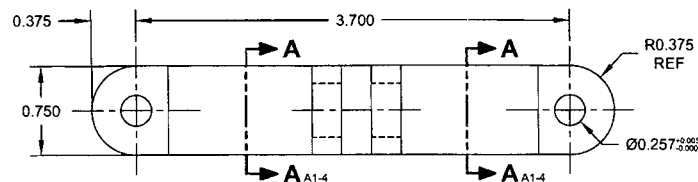
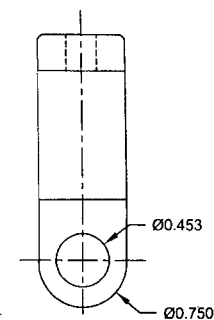
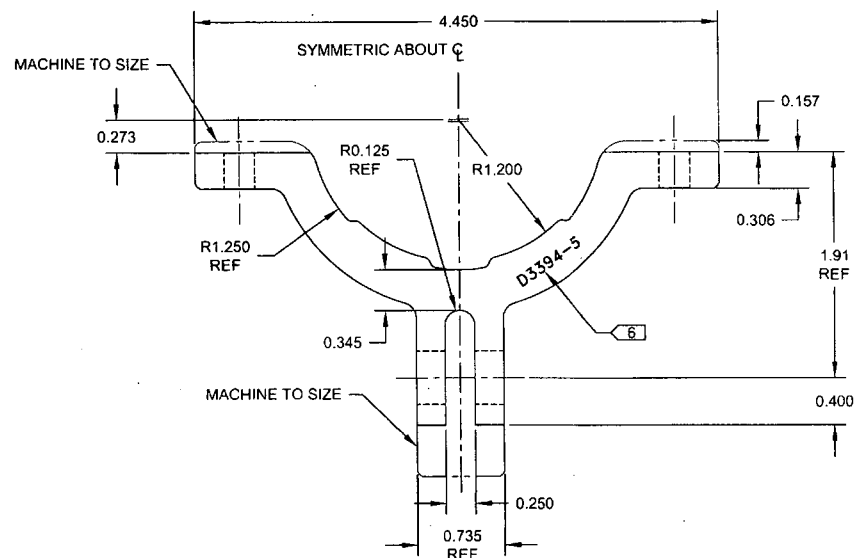
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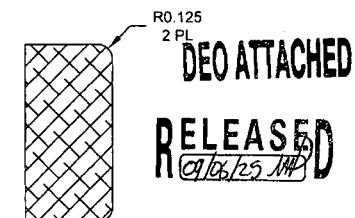
**NOTE:** Date & initial all entries



74493



D3394-5 LUG





SECTION A-A

B5-2  
B4-2  
B5-3  
B4-3  
B5-4  
B4-4

## NOTES:

- 1) MATERIAL: MAKE FROM D2423
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO DEPTH OF 0.010±0.005 IN THIS LOCATION,  
WITH TOOL A TIP RADIUS OF 0.015±0.005
- 7) WEIGHT: 0.18 lbs

DESIGN	PH	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3394	SHEET 4 OF 4
APPROVED		TITLE	SCALE
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**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

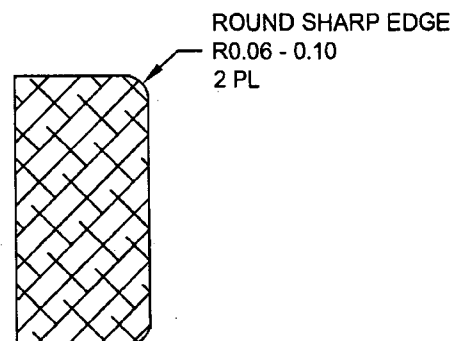
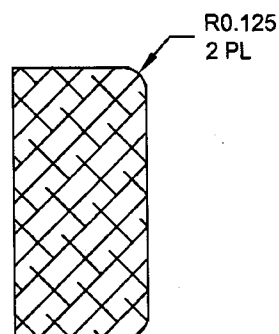
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

74493

DRAWING NO. D3394	TITLE LUG	REV. B	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3394-B-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED	MFG. APPR.	APPROVED	DE APPR.			
DATE 09.11.04	DATE 09.11.04	DATE 09.11.04	DATE 09/11/04	DATE 09/11/04			

SHEET 4 ZONE A,1 MODIFY SECTION A-A AS SHOWN:

IS:SECTION A-AWAS:SECTION A-A

REASON: DRAFTING ERROR

**RELEASED**  
2009-11-25  
*[Signature]*

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**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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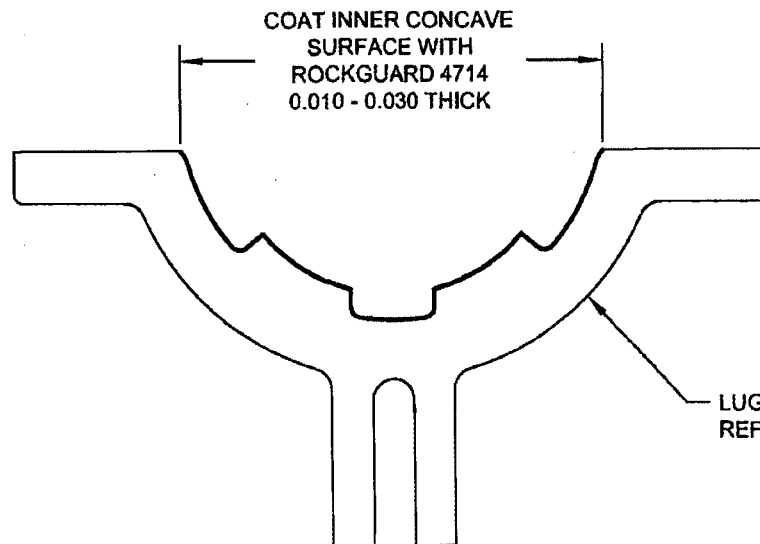
DRAWING NO. D3394	TITLE LUG	REV. B	DART AEROSPACE USA, INC ENGINEERING ORDER		D.E.O. NO. D3394-B-2	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN qp	CHECKED Sc	MFG. APPR. M	APPROVED MP		DE APPR. H		
DATE 11.05.02	DATE 11.05.09	DATE 11.05.09	DATE 11.05.08		DATE 11.05.09		

**PURPOSE**

ADD D3394-xRG OPTION

**CHANGE**

D3394-xRG MOUNTING LUGS ARE INDENTICAL TO D3394-x  
MOUNTING LUGS, HOWEVER AFTER FINISH, COAT INNER  
CONCAVE SURFACE WITH "PLUS ONE ROCKGUARD 4714"  
AS SHOWN BELOW.



D3394-1RG LUG (SHOWN)  
D3394-3RG/-5RG LUGS (SIMILAR)  
D3394-041RG/-043RG/-045RG LUG ASSEMBLIES (SIMILAR)

**RELEASED**  
2011-05-21  
LMB

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**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



20 Terry Fox Drive  
Vankleek Hill, Ontario K0B 1R0 , Canada  
Tel: (613) 678-3957  
Fax: (613) 678-3956

Delivery Slip No.: **18235**  
Date: Oct 13, 2011  
Page: 1

<b>Sold to:</b>		<b>Ship to:</b>	
Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7		Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	
<b>Order No.:</b> 15079	<b>Sold By:</b> Dewar, Eric		
<b>Shipped By:</b> your truck	<b>Ship Date:</b> Oct 13, 2011		

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D3394-3 Lug Materials supplied by Dart D2423 B#68331	Each	50	50	

The delivered goods must be inspected upon receipt to confirm compliance.  
Should there be discrepancies please notify METEC within 30 days of delivery.  
The goods are otherwise deemed accepted.

Received by \_\_\_\_\_

**Thank you for your order!**

## CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, Ont.  
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
50	D3394-3	8 6/10/17 Mounting Lug	15079

MATERIAL: supplied by DART D2423 B68331

We hereby certify that the above parts were made in conformance with applicable drawings.

*METEC Metal Technology Inc.*

Shigi Walz

Vankleek Hill, Oct. 13, 2011